

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020117**Date Inspected:** 24-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector Brett W Rice was present during the times noted above for observations relative to the work being performed at ZPMC.

Bay 1

ZPMC was observed on this date performing grinding on various welds for PCMK SB21-001. It was noted that during the grinding operation ZPMC was both cleaning the welds and grinding the welds to the appropriate contour.

Bay 2

ZPMC was observed on this date performing grinding on various welds for PCMK AP-3032-A. It was noted that during the grinding operation ZPMC was both cleaning the welds and grinding the welds to the appropriate contour.

Bay 3

This QA Inspector observed the following work in progress for Bay 3.

ZPMC was using the Fluxed Cored Arc Welding (FCAW) process.

ZPMC QC is identified as Wang Liang.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

PCMK: SP-3083-A/PL-3264-A

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CWR: 2390

Welder: 050977

WPS-345-FCAW-1G-ESAB

Bay 7

ZPMC was observed on this date performing Match Drilling for CB19.

Bay 8

ZPMC was observed on this date performing grinding on various welds for BK4-064, BK4-060, BK4-061, and BK4-057. It was noted that during the grinding operation ZPMC was both cleaning the welds and grinding the welds to the appropriate contour.

Bay 16

This QA Inspector observed the following work in progress for Bay 16.

ZPMC was using the Fluxed Cored Arc Welding (FCAW) process.

ZPMC QC is identified as Gnu Xing Hui.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

PCMK: W5-SB1-028

Weld No: 01~012, 017, 018, 032~043, 048, 049, 063~074, 079, 080, 96, 100~105, 110, 116~121

Welder: 201905

WPS-B-T-2232-ESAB

ZPMC was observed on this date performing grinding on various welds for PCMK W5-SB1-082, W5-SB1-110, W5-SB1-100, W5-SB1-097, W5-SB1-054. It was noted that during the grinding operation ZPMC was both cleaning the welds and grinding the welds to the appropriate contour.

Bay 19

This QA Inspector observed the following work in progress for Bay 19.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Gnu Xing Hui.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

PCMK: BK4-A-SD1-006

Weld No: 001~004, 022~024, 27

Welder: 259566

WPS-B-P-2211-TC-U4C-FCM

ZPMC was observed on this date performing grinding on various welds for PCMK BK4-A-006, 014. It was noted that during the grinding operation ZPMC was both cleaning the welds and grinding the welds to the appropriate contour.

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Bay 28

ZPMC was observed on this date performing grinding on various welds for PCMK E5-SB21-001, E5-SB13-081, E5-SB20-001. It was noted that during the grinding operation ZPMC was both cleaning the welds and grinding the welds to the appropriate contour.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Photos please see ; Z:\Inspector Reports\B314 Rice

Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Rice,Brett	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer
